

RH

Work Order ID 76615

76615

Page 1

November-18-11 9:18:05 AM

Item ID: D206-642-151 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Replacement Skidtube
 Start Date: 18/11/2011 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 16/01/2012 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/11/18 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3804	A								
IIN-D206-642	O								
100	DOCUMENT CONTROL	0.00							
1000									
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPP D206-642-151		CHG001						

N/A CK 12/01/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Required Date: 16/01/2012 Req'd Qty: 1.00

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110

110

Skidtubes

Skidtubes

Skidtubes

Memo

1-Deburr Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804

3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty Part Number DescriptionBatch

A/R Aluminum Rod m117889

4-Grind weld flush to cap on top surface only.

5-Cut Aft end as per dwg D3804 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804

7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt8166 & DT8169D & DT9771.

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 30 drill, spot drilling doubler at the same time.

2 SAD 11-12-10

7 BE 11-12-12

2 SAD 11-12-73

7 DE 11/12/14

W/O:		WORK ORDER CHANGES					
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11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D3804

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D3804

15-C'sink GHW rivet holes as per Dwg D3804

16- Open Aft cap hole #6.
****no wearplate holes for this skidtube****

17-Deburr tube and blow out chips from inside the tube

120

120

QC

Quality Control

QC6- Inspect dimensions to drawing

Memo

0.00

0.00

Switzly

De 11/12/14

W/O:		WORK ORDER CHANGES					
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Required Date: 16/01/2012 Req'd Qty: 1.00

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									
160	Skidtubes	0.00							
160									
Skidtubes	Memo	0.00							
Skidtubes	1-Open holes to finished size as per Dwg D3804, (without cutting fluid)								
	2-C'sink crossbolt spacer holes as per Dwg D3804(without cutting fluid)								
	3-Deburr and blow out all chips from inside the tube ✓								

SAD
11-12-14

W/O:		WORK ORDER CHANGES					
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC6- Inspect dimensions to drawing	0.00							
170						<u>1</u>	<u>0</u>	<u>BEN-1214</u>	
QC	Memo	0.00							
Quality Control									
180		0.00							
180	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required								
	2-Bond D2654-1 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting								
	Start Date: <u>11-12-14</u> Time: <u>7h20</u>								
	Finish Date: <u>11-12-15</u> Time: <u>9:00</u>								
	Pick:								
	Qty Part Number Description Batch								
	A/RSikaflex-291 <u>m119399</u>								
	Sikaflex expire date: <u>12/08/13</u>								

SAD
11-12-13

W/O:		WORK ORDER CHANGES					
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N900040100

Stop *NS2*

*** 1 ***

*** 1 ***

Run Start *NR1*

Stop *NR2*

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

0.00

0.00

Memo

Quality Control

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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200

0.00

200

Skidtubes

Skidtubes

Memo

0.00

1-remove alodine from around hole and prepare for welding

2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

QtyPart NumberDescriptionBatch

A/RAluminum Rod M117089

3-Grind welds flush as per Dwg D3804.

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/RSS Rod NONE BE 11-12-19

5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D3804. Deburr

BE 11-12-15DP 11-12-19DP 11-12-19

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	HandFinishing	0.00							
210	HandFinish	0.00							
Hand Finishing	Memo Install D2680-041 Nut Plate as per Dwg D3804								
	RH								
215	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
215	QC	0.00							
Quality Control	Memo								
220	QC10- Inspect visual per QSI004- ground welds	0.00							
220	QC	0.00							
Quality Control	Memo								

11-12-19

11.12.20

8 11/12/20

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

230 QC5- Inspect part completeness to step on W/O

0.00

230

QC

Memo

0.00

Quality Control

240 Pressure Wash per QSI005 4.3

0.00

240

HandFinish

Memo

0.00

Hand Finishing

250 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

250

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:20
320 OF
3:50

1X m-f 11/12/20

1X m-f 11/12/20

m119480

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	QC3- Inspect Part Finish	0.00							
260									
QC	Memo	0.00							
Quality Control									
270		0.00							
270	HandFinishing								
HandFinish	Memo	0.00							
Hand Finishing	1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804. Clean excess adhesive.								

1 *BD 11-12-21.*1 *BD 11-12-21.*

W/O:		WORK ORDER CHANGES					
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280		0.00							
280	HandFinishing								
HandFinish	Memo	0.00							
Hand Finishing	1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive A/RSikaflex-291 119443 Sikaflex expire date: 12/1.								
	2- Install wearplate as per dwg								
	2-Wing Walk as per Dwg D3804 and QSI 005 4.4 Batch: 119094.								
290									
290	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									

1 BR 11/12-21.

5/11/22

W/O:		WORK ORDER CHANGES					
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300 *300* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
310 *310* Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP D206-642-151 Location: _____ PPP Rev: _____	0.00 0.00							
320 *320* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

8/11/12/22

PPP 75720

11/12/29

OK 12/01/02

M.L.J 11/12/29
(1)

W/O:		WORK ORDER CHANGES					
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Picklist Print

Page 1

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Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 18/11/2011

Required Date: 16/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 10.12.08 PER IIN REV.N DD VERF:EC
REV:B 11.09.16 PER IIN REV.O DD VERF:EC

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2620

Manufactured

No

110

Each

14.0000

1

1

D2620

Skidtube, 206 Skidtube

**

SAD 11-12-01

Location

Loc Qty

Loc Code

LG

14

71616

3

374462

0

71617

6

74459

2

74460

3

D2647

Manufactured

No

110

Each

253.0000

1

1

D2647

Cap

**

BEU-12-12

Location

Loc Qty

Loc Code

LG002

253

55352

3

71171

1

73826

139

75482

110

W/O:		WORK ORDER CHANGES					
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D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 18/11/2011

Required Date: 16/01/2012

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-04

Purchased

No

180

Each

15,860.00

52

52

CR3212-4-04

Cherry Rivet

**

SAD 11-12-14

Location

Loc Qty

Loc Code

ST331

5870

116471

78

117816

3

118686

1

118840

16

119017

5762

119075

10

st510

9990

119075

9990

52

D2654-1

Manufactured

No

180

Each

4.0000

1

1

D2654-1

Web

**

SAD 11-12-14

Location

Loc Qty

Loc Code

LG

4

73794

1

73799

1

75475

1

75477

1

376759

1

D3286-1

Manufactured

No

180

Each

175.0000

2

2

D3286-1

Doubler

**

2 11/12/14

Location

Loc Qty

Loc Code

LG002

175

74111

1

74441

4

74872

59

75484

111

2

November-18-11 9:18:10 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-18-11 9:18:10 AM

Page 3

Work Order ID: 76615

76615

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 18/11/2011

Required Date: 16/01/2012

Start Qty: 1.00

Required Qty: 1.00

D2649 Manufactured No

200

Each

461.0000

19

19

D2649

Cross Bolt Spacer

**

SAD 17-12-14

Location

Loc Qty

Loc Code

LG

134

68224

2

71355

2

72704

2

72841

11

73855

117

LG001

327

65317

1

68507

11

73390

8

73857

21

73858

282

73860

4

B76793

19

D3286-3

Manufactured No

200

Each

153.0000

2

2

D3286-3

Spacer

**

BE11-12-19

Location

Loc Qty

Loc Code

LG

72

74870

72

LG001

1

74117

1

LG002

80

75483

80

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

November-18-11 9:18:10 AM

Page 4

Work Order ID: 76615

76615

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 18/11/2011

Required Date: 16/01/2012

Start Qty: 1.00

Required Qty: 1.00

D2680-041 Manufactured No

210 Each 46.0000 1 1

D2680-041

Nut Plate

**

DP 11-12-19

Location

Loc Qty

Loc Code

LG

75479

1

73334

1

ST020

45

73854

45

CR3212-4-03 Purchased No

210 Each 1,904.000 2 2

CR3212-4-03

Cherry Rivet

**

DP 11-12-19

Location

Loc Qty

Loc Code

FB

2

110139

2

ST331

1902

114859

902

119017

1000

AN960JD416 NAS1149D0463J Purchased No

210 Each 0.0000 1 1

AN960JD416

Washer

**

118384

CCR264SS3-3

Purchased No

210 Each 1,163.000 2 2

CCR264SS3-3

Cherry Rivet

**

DP 11-12-19

Location

Loc Qty

Loc Code

FP

2

113973

2

ST311

187

117849

187

ST317

974

119017

974

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

November-18-11 9:18:10 AM

Page 5

Work Order ID: 76615

76615

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 18/11/2011

Required Date: 16/01/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039-4-06

Purchased

No

210

Each

384.0000

1

1

MS27039-4-06

Screw

**

BR 11-12-21.

Location

Loc Qty

Loc Code

ST291

384

119075 ✓

384

D2651-1

Manufactured

No

270

Each

745.0000

6

6

D2651-1

Plug

**

BR 11-12-21.

Location

Loc Qty

Loc Code

FP

745

57869

1

66445

10

69018

2

70839

2

71037

31

73827 ✓

699

D2651-3

Manufactured

No

270

Each

1,235.000

6

6

D2651-3

O-Ring

**

BR 11-12-21.

Location

Loc Qty

Loc Code

FP

1235

61962

12

73489

223

73828 ✓

1000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

November-18-11 9:18:10 AM

Page 6

Work Order ID: 76615

76615

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 18/11/2011

Required Date: 16/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3873-1 Manufactured No

280 Each

821.0000 14 14

D3873-1

Bushing

**

BR 11-12-21.

Location

Loc Qty

Loc Code

ST088

76792

821

64760

1

68247

4

73829

19

73830

16

73832

400

75481

381

14.

D2646 Manufactured No

280 Each

235.0000 1 1

D2646

Aft Cap

**

BR 11-12-21.

Location

Loc Qty

Loc Code

FP002

218

73294

20

73825

198

FP004

8

68280

5

70945

1

71070

2

FP005

4

71038

4

FP006

5

62678

5

D3805-041 Manufactured No

280 Each

1.0000 1 1

D3805-041

Wearplate Assembly Fwd, Low Gear

**

BR 11-12-21.

Location

Loc Qty

Loc Code

FP001

75487

1

74893

1

1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

November-18-11 9:18:10 AM

Page 7

Work Order ID: 76615

76615

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 18/11/2011

Required Date: 16/01/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-08

Purchased

No

280

Each

1,747.000

2

2

MS27039-1-08

Screw

**

BK 11-12-21

Location

Loc Qty

Loc Code

ST291

1747

117423

117

118378

130

118910 ✓

500

119075

500

119109

500

2

MS21042L3

Purchased

No

280

Each

8,753.000

7

7

MS21042L3

Nut

**

BK 11-12-21

Location

Loc Qty

Loc Code

ST300

255

117441

16

117885

35

118451

5

118927

199

ST516

6000

119017

6000

ST518

2498

119075 ✓

2498

7

D3805-045

Manufactured

No

280

Each

5.0000

1

1

D3805-045

Wearplate Assembly Aft, Low Gear

**

BK 11-12-31

Location

Loc Qty

Loc Code

FP

5

73817

1

74896

1

74938

3

1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-18-11 9:18:10 AM

Page 8

Work Order ID: 76615

76615

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 18/11/2011

Required Date: 16/01/2012

Start Qty: 1.00

Required Qty: 1.00

AN960JD10L ☒ NAS1149D0332J ☒ Purchased

No

118389

280

Each

0.0000

2

2

*AN960JD10L *

**

2

BR 11-12-21

Washer

AN3-37A Purchased

No

280

Each

1,966.000

7

7

AN3-37A

**

BR 11-12-21

Bolt

Location

Loc Qty

Loc Code

ST354

4

117619

4

ST518

1962

119086 ✓

1962

7

NAS1149D0363J Purchased

No

280

Each

4,434.000

7

7

*NAS1149D0363J *

**

BR 11-12-21

Washer

Location

Loc Qty

Loc Code

ST019

16

117505

16

ST295

3000

119537

3000

ST298

1418

117601

148

118077

1

118612

55

118968 ✓

1214

7

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

ITEM	Qty -041	Qty -043	Part Number	Description
1	X		D3804-041	SKIDTUBE ASSEMBLY, 206 A/B LOW
2		X	D3804-043	SKIDTUBE ASSEMBLY, 206 A/B HIGH
5	1	1	D2600-1-160	EXTRUSION
6	1	1	D2646	AFT CAP
7	1	1	D2647	CAP
8	19	20	D2649	CROSS BOLT SPACER
9	6	8	D2651-1	PLUG
10	6	8	D2651-3	O-RING
11		1	D2654-3	WEB
12	1		D2654-1	WEB
13	1	1	D2680-041	NUT PLATE
14	2	2	D3286-1	DOUBLER
15	2	2	D3286-3	STUD
21	2	2	AN960JD10L	WASHER
22	1	1	AN960JD416	WASHER
23	2	2	CCR264SS3-3	RIVET
24	2	2	CR3212-4-03	RIVET
25	52	52	CR3212-4-04	RIVET
26	2	2	MS27039-1-08	SCREW
27	1	1	MS27039-4-06	SCREW

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

SHOP
RETURN
ENGINEER
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 76615 M.C.J.
11/11/18

RELEASED
09.03.03
PC Ecn 09-538

REV.	NEW ISSUE	DESCRIPTION	MB	08.07.07
DESIGN	97	DART AEROSPACE USA, INC		
DRAWN	97	PORT HADLOCK, WA		
CHECKED	97	DRAWING NO.	REV. A	
MFG. APPR.	97	D3804	SHEET 1 OF 5	
APPROVED	97	TITLE	SCALE	
DE APPR.	97	SKIDTUBE ASSEMBLY, 206A/B	NTS	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

RELEASED
09.03.03



DESIGN	97	DART AEROSPACE USA, INC	
DRAWN		PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	BE	D3804	SHEET 2 OF 5
APPROVED	TH	TITLE	SCALE
DE APPR.		SKIDTUBE ASSEMBLY, 206A/B	NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

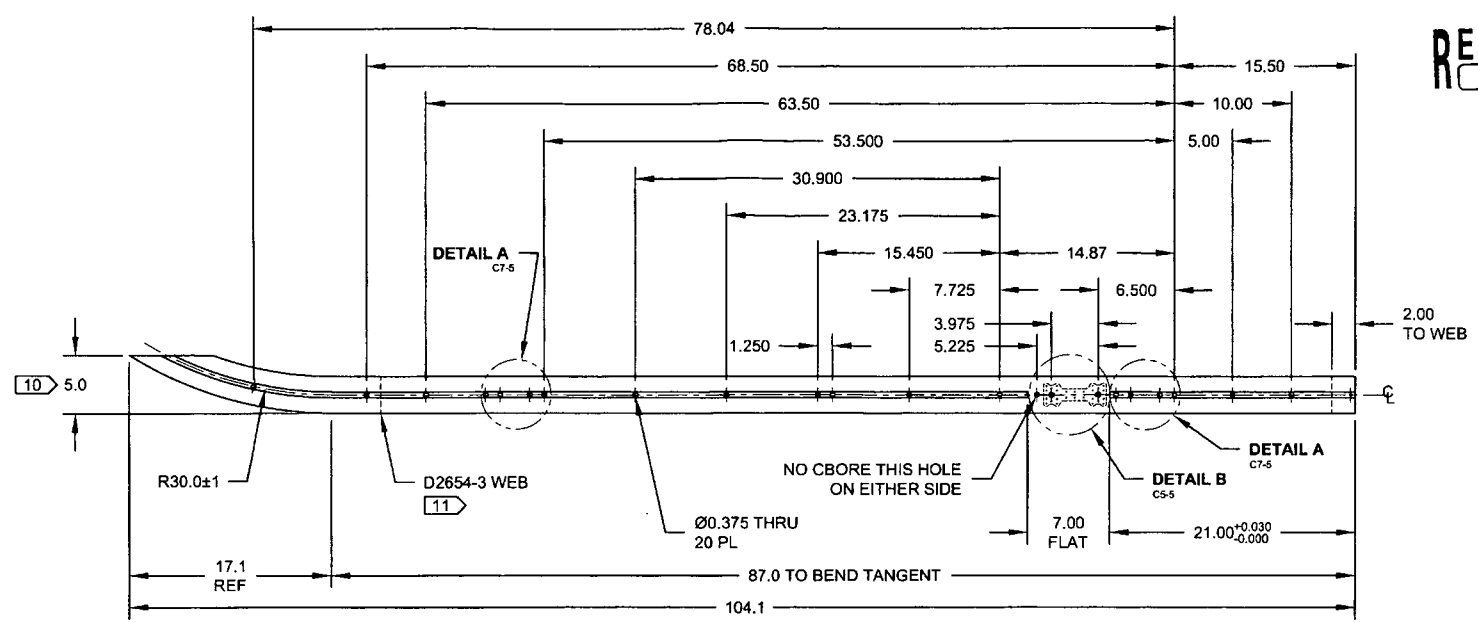
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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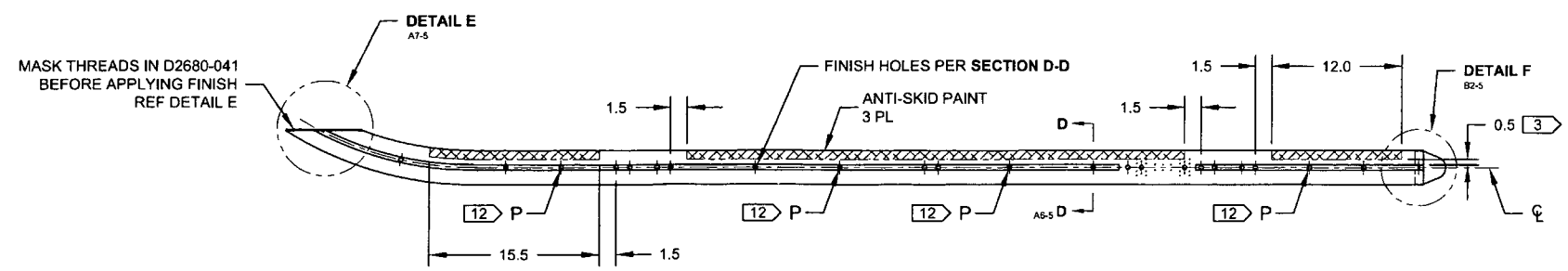
NOTE: Date & initial all entries

76615

RELEASED
(P 09-03-03)



D3804-043 BENDING/DRILLING DETAIL



D3804-043 ASSEMBLY/FINISHING DETAIL

DESIGN	91	DART AEROSPACE USA, INC	
DRAWN	91	PORT HADLOCK, WA	
CHECKED	91	DRAWING NO.	REV. A
MFG. APPR.	91	D3804	SHEET 3 OF 5
APPROVED	91	TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

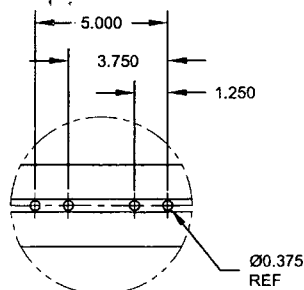
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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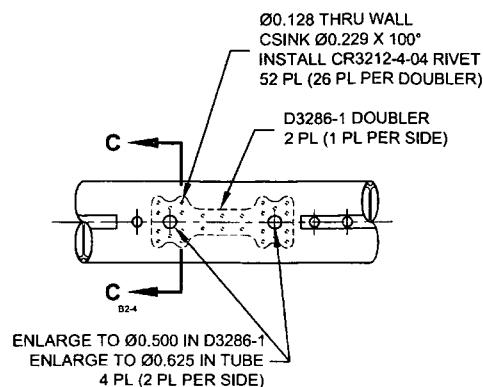
NOTE: Date & initial all entries

76615

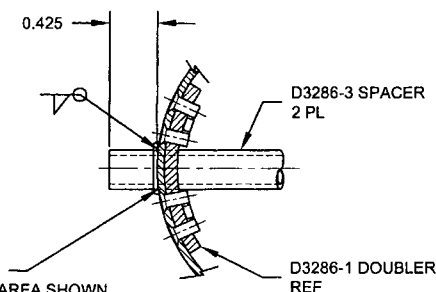
RELEASED
UP 09.03.07



DETAIL A
D6-2
C2-2
D6-3
C2-3
SCALE NONE

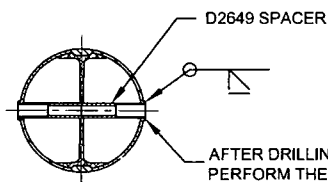


DETAIL B
C3-2
C3-3
SCALE NONE



- TO INSTALL D3286-1/-3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH

SECTION C-C C6-4
PARTIAL SECTION
SCALE NONE



- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.03 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. CBORE TO Ø0.313 X 0.75 DP (EXCEPT WHERE INDICATED)

SECTION D-D A4-2
A4-3
FOR Ø0.375 HOLES ONLY
SCALE NONE

DESIGN	91	DART AEROSPACE USA, INC	
DRAWN	91	PORT HADLOCK, WA	
CHECKED	91	DRAWING NO.	REV. A
MFG. APPR.	91	D3804	SHEET 4 OF 5
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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

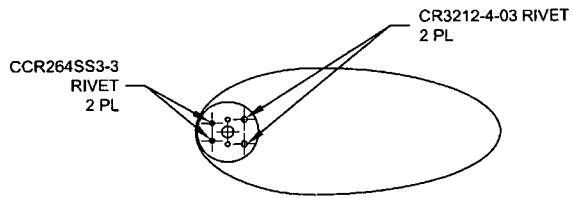
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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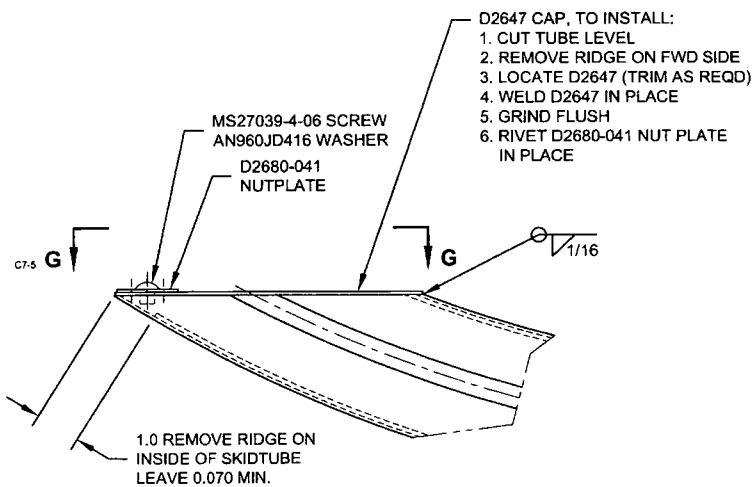
NOTE: Date & initial all entries

76615

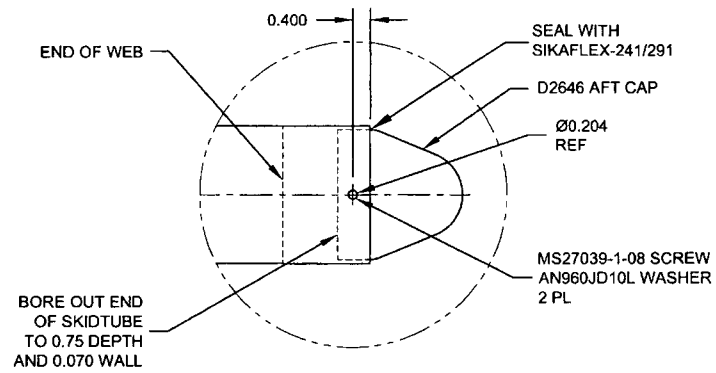
RELEASED
97 09 03 03



VIEW G-G
SCALE NONE A7-5



DETAIL E
SCALE NONE B7-2 B7-3



DETAIL F
SCALE NONE B2-2 B2-3

DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	97	PORT HADLOCK, WA	
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MFG. APPR.	97	D3804	SHEET 5 OF 5
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NOTE: Date & initial all entries

NO. 274

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Berley Elliott
Job number: 75391
Part number: 206 642 151
Description: 206 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Sal Harris Date of Test Coupon 11-11-18

Welder Sal Harris Date of Test Coupon 11-11-18

The above named individual is qualified in accordance with AWS D17.1.2001 to weld